



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4149-1

Job Sheet 185989



Part No: D4149-1

Job Qty: 20 ea

Part Name: Crosstube Lug Plate, Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.03.03 as per revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/30/18	0.00	3.05	Waterjet - Flow		SL 18/11/18
110	QC	20 pcs		11/30/18	0.00	0.00	QC2 Waterjet-3		SL 18/11/18
120	QC	20 pcs		11/30/18	0.00	0.00	QC8-4		38
150	Packaging	20 pcs		11/30/18	0.00	0.00	Packaging3		9-89
160	QC21-SA	20 Ea		11/30/18	0.00	0.00	QC21		DAS 21 9-89

NOV 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.7100 sf (.1355 ea)	100-Waterjet - Flow - 1	5114878

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	3	22	0

Part Specifications

Specifications could not be found.

Plex 11/8/18 8:19 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 15%;">Skid-tube</td> <td style="width: 15%;">Cross tube</td> <td style="width: 15%;">Water Jet</td> <td style="width: 15%;">Engineering</td> </tr> <tr> <td>Machining</td> <td>Small Fab</td> <td>Prod. Eng. Coord.</td> <td>Quality</td> </tr> <tr> <td></td> <td>Finishing</td> <td>Rec/Store/Packaging</td> <td>Other</td> </tr> <tr> <td></td> <td>Composite</td> <td>Supplier</td> <td></td> </tr> </table>				Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality		Finishing	Rec/Store/Packaging	Other		Composite	Supplier				
Skid-tube	Cross tube	Water Jet	Engineering																					
Machining	Small Fab	Prod. Eng. Coord.	Quality																					
	Finishing	Rec/Store/Packaging	Other																					
	Composite	Supplier																						
Date : _____		Disposition		MRB (QSI042) Approval																				
				Completed By																				
				Lead hand / Supervisor Approval Verification																				
				QC / QA Coordinator Approval																				
		CATEGORY <table style="width: 100%;"> <tr> <td style="width: 50%;">☐ Power Loss/Surge</td> <td style="width: 50%;">☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>			☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
☐ Power Loss/Surge	☐ Positioned Wrong																							
☐ Folio/Program	☐ Outside Dimensions																							
☐ Grain	☐ Over/Under tolerance																							
☐ Weld	☐ Part Incorrect																							
☐ Wrong Stock Pulled	☐ Part Lost/Missing																							
☐ Out of Sequence	☐ Part Moved																							
☐ Off-set	☐ Drawing																							
☐ Mislabeled	☐ Finish																							
☐ Fit/Function	☐ Misread																							
☐ Misaligned/off center	☐ Turning Sequence																							
		<table style="width: 100%;"> <tr> <td style="width: 50%;">☐ BOM/Route</td> <td style="width: 50%;">☐ Cracks</td> </tr> <tr> <td>☐ Broken/Damage/Defect</td> <td>☐ Crimp/Kink/Ripple/Wave</td> </tr> <tr> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Cuffs</td> </tr> <tr> <td>☐ Contamination</td> <td>☐ Crushing</td> </tr> <tr> <td>☐ Countersink</td> <td>☐ Heat Treat</td> </tr> <tr> <td>☐ Cut Too Short</td> <td>☐ Wave/Twist in Tube</td> </tr> <tr> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Marks/Chatter</td> </tr> <tr> <td>☐ Drill Holes</td> <td></td> </tr> </table>			☐ BOM/Route	☐ Cracks	☐ Broken/Damage/Defect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Cuffs	☐ Contamination	☐ Crushing	☐ Countersink	☐ Heat Treat	☐ Cut Too Short	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Marks/Chatter	☐ Drill Holes					
☐ BOM/Route	☐ Cracks																							
☐ Broken/Damage/Defect	☐ Crimp/Kink/Ripple/Wave																							
☐ Inspection Incomplete/Unqualified	☐ Cuffs																							
☐ Contamination	☐ Crushing																							
☐ Countersink	☐ Heat Treat																							
☐ Cut Too Short	☐ Wave/Twist in Tube																							
☐ Instructions Incomplete/Unclear	☐ Marks/Chatter																							
☐ Drill Holes																								
		<table style="width: 100%;"> <tr> <td style="width: 50%;">☐ Training</td> <td style="width: 50%;">☐ Use for Testing</td> </tr> <tr> <td>☐ Poor Information</td> <td>☐ Rushing</td> </tr> <tr> <td>☐ Product Improvement</td> <td>☐ Process Improvement</td> </tr> <tr> <td>☐ Manufacturing Process</td> <td>☐ Past Due</td> </tr> </table>			☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due												
☐ Training	☐ Use for Testing																							
☐ Poor Information	☐ Rushing																							
☐ Product Improvement	☐ Process Improvement																							
☐ Manufacturing Process	☐ Past Due																							
		OTHER : _____																						

Dart Aerospace Ltd.
 1270 Aboureen Street, K7
 Haverhill, ON K6A 1K7
 CANADA
 TEL: 513 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S126638

Part: D4149-1
 Job No: 185989
 Serial No/Batch: S126638

Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 11/10/18

Envir
 Doi
 Equip/Ti
 Handling

Material
 Internal Transport
 Tribal Knowledge
 LOA
 Substation
 Past Expiry Date
 Misidentified

DART AEROSPACE LTD		Work Order: 185989
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø0.129			VSC-01	
Ø0.191	+0.005/-0.001	Ø0.192			TABE	
Ø0.257	+0.006/-0.001	Ø0.258				
Ø0.38	+0.006/-0.001	Ø0.38				
0.380	+/-0.010	0.380				
0.469	+/-0.010	0.470				
0.310	+/-0.010	0.309				
0.750	+/-0.010	0.752				
3.25	+/-0.030	3.25				
0.65	+/-0.030	0.659				
0.63	+/-0.030	0.638				
5.46	+/-0.030	5.467				
3.80	+/-0.030	3.806				
2.13	+/-0.030	2.133				
1.313	+/-0.010	1.310				
0.625	+/-0.010	0.624				
0.375	+/-0.010	0.378				
1.175	+/-0.010	1.177				
0.752	+/-0.010	0.755				
1.588	+/-0.010	1.590				
1.587	+/-0.010	1.590				
11.15	+/-0.030	11.15				
0.750	+/-0.010	0.749				
1.55	+/-0.030	1.552				
1.12	+/-0.030	1.1247				
8.42	+/-0.030	8.42				
2.70	+/-0.030	2.698				
0.125	+/-0.010	0.115				
Ø0.252	+0.003/-0.000	Ø0.253				

Measured by:	SC
Date:	18/11/10

Audited by:	JAC 38
Date:	NOV 13 2018

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

